

Work Order ID 113242

August-13-14 10:48:46 AM

113242

ship 22 out
on SAP.

Page 1

Item ID: D350-567-141

Revision ID:

Item Name: Floor Window Close Out

Start Date: 3/14/14 Start Qty: 1.00

Required Date: 3/14/14 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: ML5 Date: 14-02-14 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
DSI 9590	E								

100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-567-141 CHG003								

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

ML5 14-08-13

DAS
38
9-89 14/08/13

1X DAS
28
9-89 AUG 13 2014

1 DAS
38
9-89 14/08/14

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113242

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Item ID: D350-567-141

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Floor Window Close Out

Start Date: 3/14/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/14/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D350-567-141

Location: 033

0.00

0.00

①

DAS
06
9-89

AUG 19 2014

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

MLJ 14-08-20

14-8-19

Picklist Print

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Work Order ID: 113242

113242

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 3/14/14

Required Date: 3/14/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.11.09 new issue DD verf:JLM IPP REV:B
12.01.23 AS PER ECN12-511 DD VEF:EC IPP REV:C 12.03.05
AS PER ECN12-537 DD VEF:EC IPP REV:C 13.04.01 AS PER
DSI9590 REV.E DD VEF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3802-1		Manufactured	No	DAS		110	f	265.0100	2	2			
D3802-1		DAS		38					**		DAS		
Windows Seal (\$ Per Foot)		38		9-89							28		DAS
		9-89									9-89		06
													9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				st417		265.01							
				112283		48							
				114190		9							
				116673		10							
				117766		0.01							
				122222		198							
D4434-041		Manufactured	No	DAS		110	Each	0.0000	1	1			
D4434-041		DAS		38					**		DAS		
Fwd Bracket Assembly		38		9-89							28		DAS
		9-89									9-89		06
D4435-045		Manufactured	No	DAS		110	Each	7.0000	1	1			
D4435-045		DAS		38					**		DAS		
T/R Bellcrank Cover Assembly		38		9-89							28		DAS
		9-89									9-89		06
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST273		1							
				107532		1							
				ST373		6							
				122450		6							

cut(1) at 24"

AUG 14 2014

2x

120660

1x

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Work Order ID: 113242

113242

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 3/14/14

Required Date: 3/14/14

Start Qty: 1.00

Required Qty: 1.00

D4435-9
 DAS 38
 9-89
 D4435-9
 Bracket

Manufactured No

110 Each 12.0000

2 2

DAS 28
 9-89
 AUG 14 2014
 06
 9-89

Location Loc Qty Loc Code

ST103 12

121093 12

D4436-041
 D4436-041
 Aft Bracket Assembly

Manufactured No

110 Each 0.0000

1 1

DAS 28
 9-89
 121034
 06
 9-89

D4441-1
 D4441-1
 Rubber Seal

Manufactured No

110 f 1.0000

2 2

DAS 28
 9-89
 120932
 06
 9-89

Location Loc Qty Loc Code

ST425 1

86185 1

AN3-3A
 AN3-3A
 Bolt

Purchased No

110 Each 633.0000

7 7

DAS 28
 9-89
 06
 9-89

Location Loc Qty Loc Code

ST350 633

m127815 4

m128973 69

m129591 360

m129706 200

7x

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113242

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 3/14/14

Required Date: 3/14/14

Start Qty: 1.00

Required Qty: 1.00

AN525-832R7

Purchased

No

110

Each

212.0000

2

AN525-832R7

Screw

DAS
38
9-89

**

DAS
28
9-89

AUG 14 2014

68-6
90
SVC

Location

Loc Qty

Loc Code

ST328

212

120560

9

m127363

103

m129909

100

2x

MS21042L06

Purchased

No

110

Each

481.0000

7

MS21042L06

Nut

DAS
38
9-89

**

DAS
28
9-89

68-6
90
SVC

Location

Loc Qty

Loc Code

ST307

481

m127304

3

m128401

78

m128976

200

m129499

200

7x

MS21042L08

Purchased

No

110

Each

3,546.000

2

MS21042L08

Nut

DAS
38
9-89

**

DAS
28
9-89

68-6
90
SVC

Location

Loc Qty

Loc Code

ST306

3546

123900

1

125445

268

m127304

99

m127410

1262

m128401

1500

m128429

216

m129541

200

2x

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Work Order ID: 113242

113242

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 3/14/14

Required Date: 3/14/14

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

3,706.000

5

MS21042L3

Nut

DAS
38
9-89

Location

Loc Qty

Loc Code

ST307

3706

123900

948

M127410

11

M127831

41

M128401

42

M128754

2664

DAS
28
9-89

AUG 14 2014

DAS
06
9-89

MS21059L3

Purchased

No

110

Each

507.0000

2

MS21059L3

Nut Plate

DAS
38
9-89

Location

Loc Qty

Loc Code

CA

17

M129682

17

ST305

490

114449

4

M127743

2

M128936

4

M128976

31

M129472

49

M129934

400

DAS
28
9-89

DAS
06
9-89

MS35206-229

Purchased

No

110

Each

121.0000

7

MS35206-229

Screw

DAS
38
9-89

Location

Loc Qty

Loc Code

ST282

121

M126084

21

M129795

100

DAS
28
9-89

DAS
06
9-89

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Work Order ID: 113242

113242

Parent Item: D350-567-141

D350-567-141

Parent Item Name: Floor Window Close Out

Start Date: 3/14/14

Required Date: 3/14/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

110

Each

3,193.000

12 12

NAS1149F0332P

Washer

DAS
38
9-89

Location

Loc Qty

Loc Code

ST275

3193

122063

205

123900

12

125646

106

m123185

47

m127831

2500

m128401

23

m129541

300

**

DAS
28
9-89

AUG 14 2014

DAS
06
9-89

NAS1149FN616P

Purchased

No

110

Each

250.0000

14 14

NAS1149FN616P

WASHER

DAS
38
9-89

Location

Loc Qty

Loc Code

ST275

250

M127703

250

**

DAS
28
9-89

DAS
06
9-89

NAS1149FN816P

Purchased

No

110

Each

580.0000

2 2

NAS1149FN816P

WASHER

DAS
38
9-89

Location

Loc Qty

Loc Code

ST275

580

117316

580

**

DAS
28
9-89

DAS
06
9-89

DAS
38
9-89

MTT 127743 X2

DAS
06
9-89

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-567 REV. D OR EARLIER
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-567 REV. 1 OR EARLIER
REF CANADIAN STC: SH92-18
FAA STC: SH989NE
FAA STC: SH990NE

1.0 Purpose

The purpose of this service instruction is to add the D350-567-141 Close-out Kit, which is intended for customers wishing to operate their aircraft with the interior floor window removed. The D350-567-141 Floor Window Close-out Kit provides a barrier around the interior and exterior vertical reference floor window to prevent objects from falling into the aircraft controls when the interior floor window is removed as shown in Figure 1.

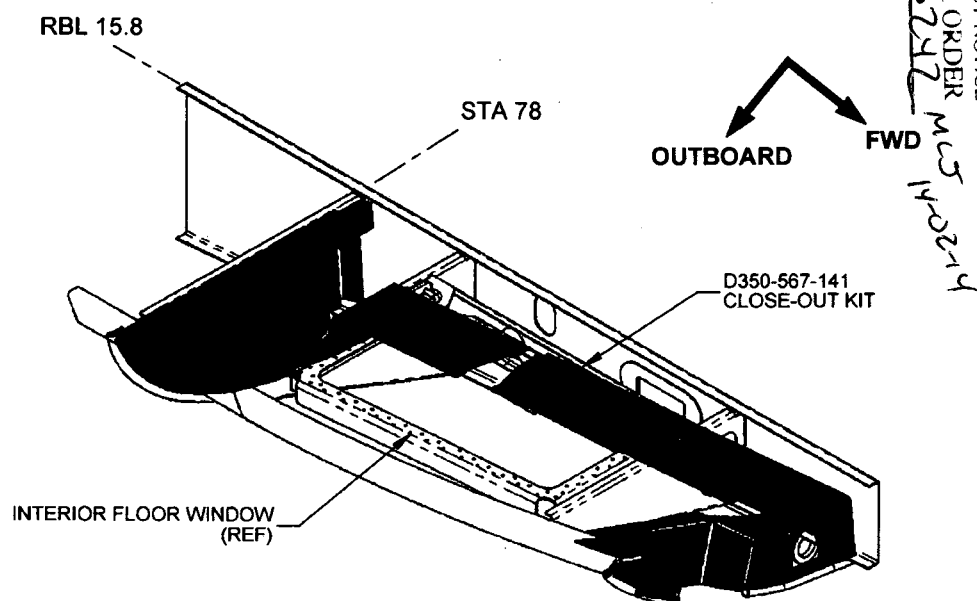


Figure 1. Floor Window Close-out Kit Installation

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 13.09.11
CERT. NO.: SH92-18
ISSUE NO.: 6

D	CLARIFY FIGURES 3-12	VS	13.09.11
C	CORRECT TYPO NAS1149FN816P WAS NAS1149FN882P	RF	12.03.13
B	MS35206-229 WAS AN525-632R6; NAS1149FN616P (Qty 14) WAS (Qty 9); MS21042L06 (Qty 7) WAS (Qty 9); ADD AN525-832R7, NAS1149FN882P & MS21042L08	RF	12.02.22
A	NEW ISSUE	RF	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	N/A	DSI 9590	SHEET 1 OF 15
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT	NTS
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2.0 Part List

Qty -141	Part Number	Description
X	D350-567-141	FLOOR WINDOW CLOSE-OUT KIT
1	D3802-1-024	SEAL (24")
1	D4434-041	FWD BRACKET ASSEMBLY
1	D4434-047	COVER ASSEMBLY
1	D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	D4435-9	BRACKET
1	D4436-041	AFT BRACKET ASSEMBLY
1	D4441-1-240	RUBBER SEAL (24")
7	AN3-3A	BOLT
2	AN525-832R7	SCREW
7	MS21042L06	NUT (OR MS21042-06)
2	MS21042L08	NUT (OR MS21042-08)
5	MS21042L3	NUT (OR MS21042-3)
2	MS21059L3	NUTPLATE
7	MS35206-229	SCREW
12	NAS1149F0332P	WASHER (AN960-10L)
14	NAS1149FN616P	WASHER (OR AN960-6L)
2	NAS1149FN816P	WASHER (OR AN960-8L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141 Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kg	1.66 m	2.94 m-kg

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141 Close-out Kit. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 — OK to remove D3295-041
 - D350-567-031 — OK to remove D3212-1
 - D350-567-011 — OK to remove D2214
 - D350-567-021 — OK to remove D2951
- It is acceptable to drill/trim the D350-567-141 Close-out Kit as required to improve fit.

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MFG. APPR.	N/A	DSI 9590 SHEET 2 OF 15
APPROVED		TITLE SCALE
DE APPR.		FLOOR WINDOW CLOSE-OUT KIT NTS
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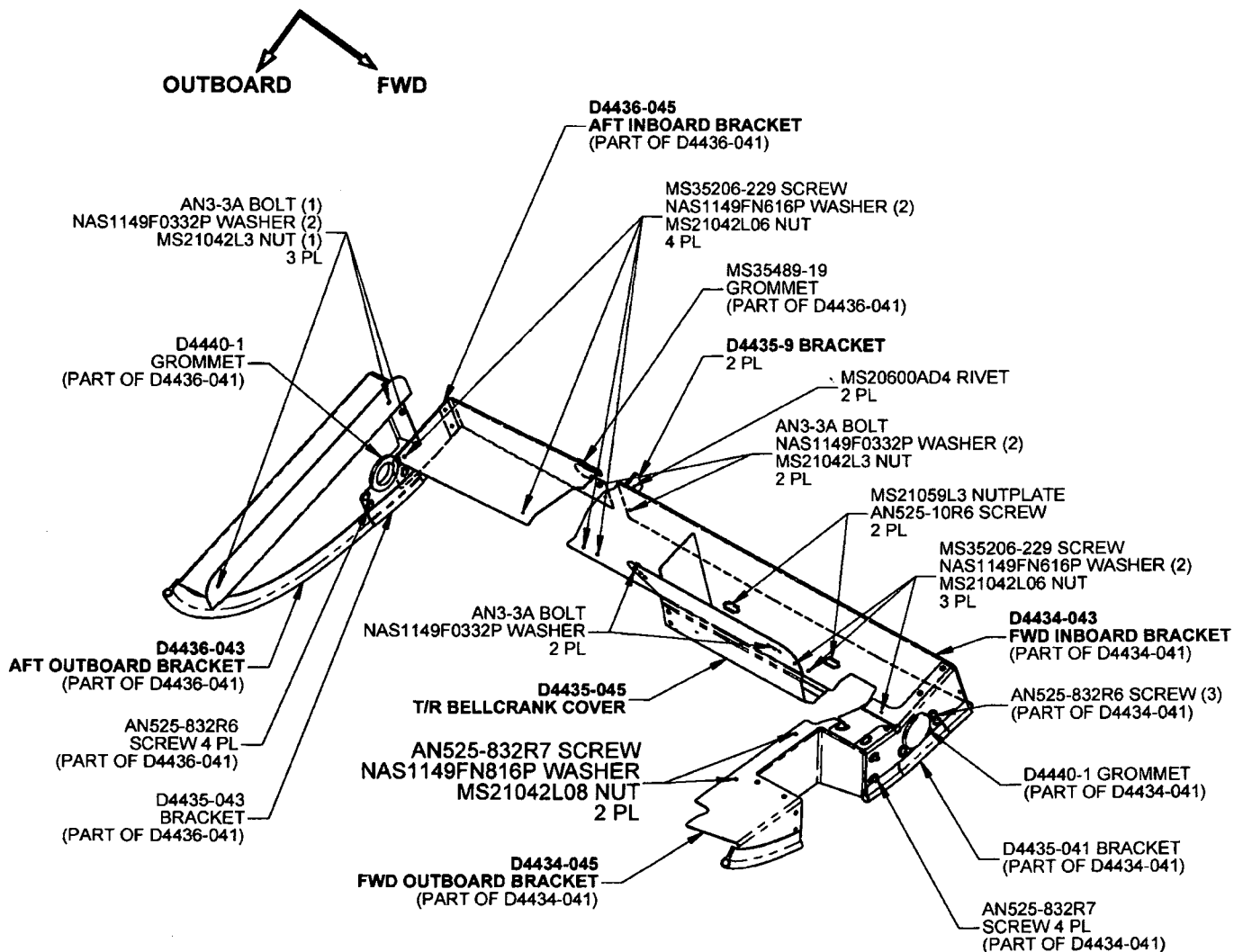


Figure 2. Floor Window Close-out Kit Installation

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BRANCH
DAO # 01-O-01

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BY:

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DESIGN	08	DART AEROSPACE LTD	
DRAWN	08	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	N/A	DSI 9590	SHEET 3 OF 15
APPROVED	05	TITLE	SCALE
DE APPR.	01	FLOOR WINDOW CLOSE-OUT KIT	NTS
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- 4.1 Temporarily install D4436-043 Aft Outboard Bracket and D4436-045 Aft Inboard Bracket using clecos and/or clecos clamps. Before drilling holes:
 - a) Position the D4436-043 Aft Outboard Bracket so the flange contacts the main beam as shown in Figure 3.
 - b) Confirm that the D4436-043 Aft Outboard Bracket and beam angle are parallel as shown in Figure 4.
- 4.2 Temporarily install D4434-043 Fwd Inboard Bracket and D4434-045 Fwd Outboard Bracket using clecos and cleco clamps. Confirm there is no contact between D4436-045 Aft Inboard Bracket and D4434-043 Fwd Inboard Bracket and main beam gusset as shown in Figure 5.
- 4.3 If aircraft is equipped with Collective Circuit Breaker Board box trim D4434-043 Fwd Inboard Bracket as shown in Figure 14. Install D4434-047 Cover as shown in Figure 13. Note: Confirm the D4434-047 Cover fits over the Collective Circuit Breaker Board box. Adjust opening as required.
- 4.4 Drill off rivets holding plastic wire bundle stand offs. Transfer drill $\varnothing 0.144$ holes to D4436-045 Aft Inboard Bracket per Figure 6. Transfer drill 2 x $\varnothing 0.144$ holes to D4434-043 Fwd Inboard Bracket per Figure 7. Transfer drill 2 x $\varnothing 0.144$ holes for D4434-043 Fwd Inboard Bracket per Figure 8. Before drilling confirm the D4434-043 and D4436-045 brackets are flush with outboard edge of main beam flange. Assemble D4436-045 Aft Inboard Bracket and D4434-043 Fwd Inboard Bracket and wire bundle stand offs to main beam flange using MS35206-229 screw, NAS1149FN616P washer and MS21042L06 nut.
- 4.5 Install D4436-043 Aft Outboard Bracket using AN3-3A bolt and NAS1149F0332P washer and MS21042L3 nut per Figure 9.
- 4.6 Remove 2 rivets holding RH heating plastic stand off as shown in Figure 10. Position the D4435-9 Brackets on the in/outboard sides of the cross beam and transfer drill 2 x $\varnothing 0.129$ holes from crossbeam to both D4435-9 Brackets. Install D4435-9 Brackets and RH heating plastic stand off using MS20600AD4 rivets or equivalent.
- 4.7 Drill a pilot hole from D4435-9 Bracket to the D4434-045 Fwd Inboard Bracket and D4436-045 Aft Inboard Bracket and open to $\varnothing 0.191$. Install AN3-3A bolt, NAS1149F0332P washer and MS21042L3 nut as shown in Figure 10. Be sure to maintain edge distance.
- 4.8 Transfer drill 2 x $\varnothing 0.144$ holes from crossbeam to D4434-045 Fwd Outboard Bracket if holes exist in crossbeam. If holes do not exist, drill 2 x $\varnothing 0.144$ holes at either end of D4434-045 bracket as shown in Figure 11. Install AN525-832R7 Screws, NAS1149FN816P washer and MS21042L08 nuts.
- 4.9 Align D4435-045 T/R Bellcrank Cover with existing holes in RH seat track lower frame and temporarily install using clecos and/or cleco clamps as shown in Figure 12.
- 4.10 Transfer drill 2 x $\varnothing 0.098$ holes from D4435-045 T/R Bellcrank Cover to D4434-043 Fwd Inboard Bracket. Open holes to $\varnothing 0.191$ and install MS21059L3 nut plate into D4434-043 Fwd Inboard Bracket as shown in Figure 12 and Figure 13. Install D4435-045 T/R Bellcrank Cover using AN525-10R6 screw, AN3-3A bolt and NAS1149F0332P washer per Figure 12 and Figure 13.
- 4.11 The D4440-1 grommets are provided to facilitate the routing of wiring harness thru the close-out kit as required. The wiring harness should be secure to the aircraft structure per AC 43.13.13-1B or AS350 Chapter 20.02.01.
- 4.12 Use the D3802-1-024 Seal to fill gaps between the brackets and the cowlings that are larger than 0.25 inch.
- 4.13 Perform travel/interference check of the flight controls to ensure there is no interference and all controls still have full travel.
- 4.14 Ensure there is a gap between the components of the D350-567-141 Close-out Kit and the aircraft structure so that the Close-out Kit does not chafe, interfere, or cause damage to the surrounding aircraft structure. In areas where the D350-567-041 Close-out Kit may contact the aircraft structure, protect from abrasion using chafing tape or a layer Proseal 890 or MIL-S-8802 class B2 sealant or equivalent as required.

CANADA
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AIRCRAFT CERTIFICATION
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DAO # 01-O-01

APPROVED

BY:

D. SHEPHERD (DE # 02)

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MFG. APPR.	N/A	DSI 9590 SHEET 4 OF 15
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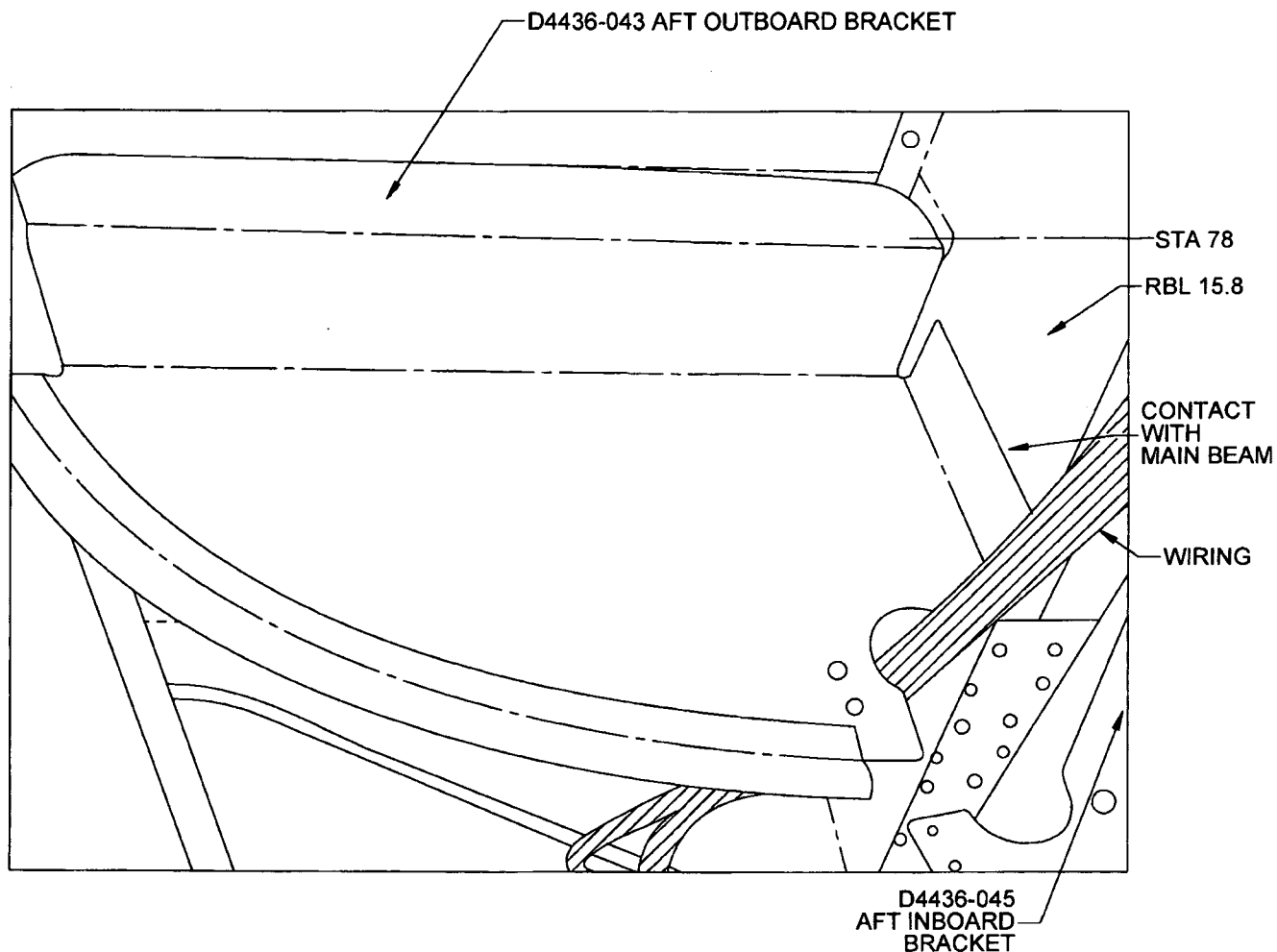


Figure 3. D4436-043 Aft Outboard Bracket Installation

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	N/A	DSI 9590	SHEET 5 OF 15
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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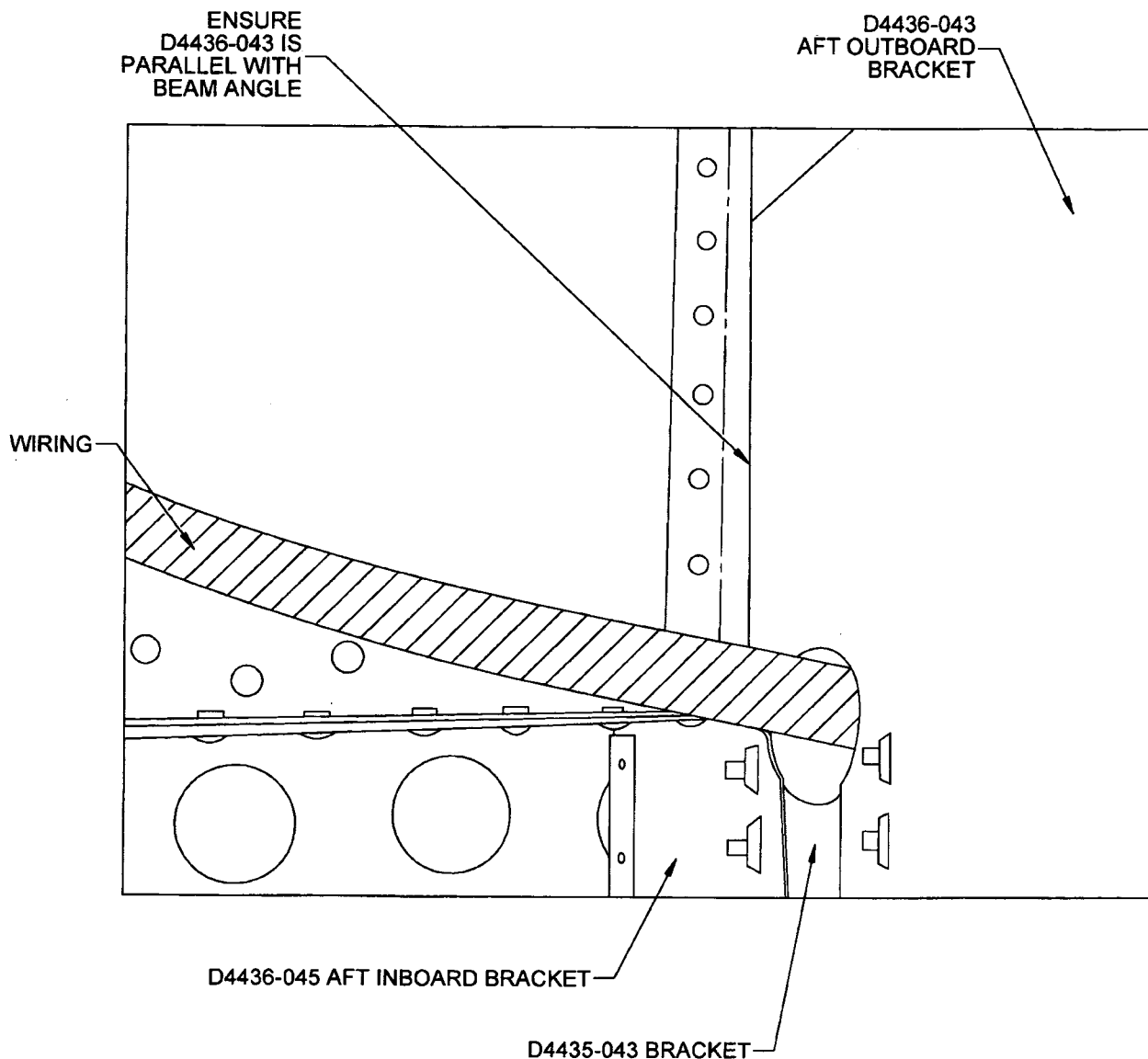


Figure 4. D4436-043 & D4435-043 Brackets Installation D

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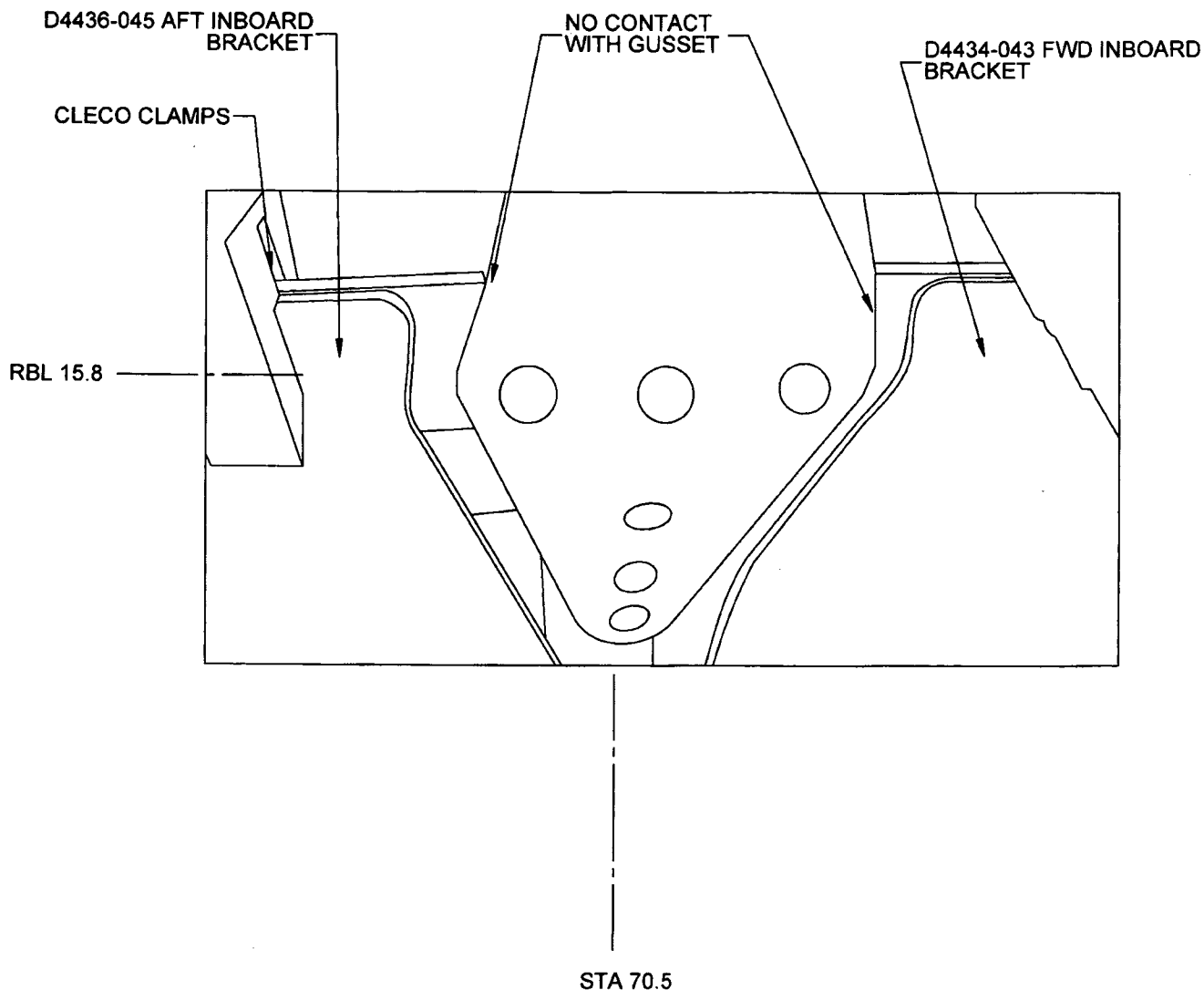


Figure 5. D4436-045 & D4434-043 Brackets Installation

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AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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D4436-043
AFT OUTBOARD
BRACKET

CONFIRM
FLUSH WITH
OUTBOARD
EDGE OF MAIN
BEAM FLANGE

WIRING

PLASTIC STAND OFF
REF

RIVET HOLE
FOR PLASTIC
STAND OFF

CLECO CLAMPS

D4436-045
AFT INBOARD
BRACKET

Figure 6. D4436-043 & D4436-045 Brackets Installation



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MFG. APPR.	N/A	DSI 9590	SHEET 8 OF 15
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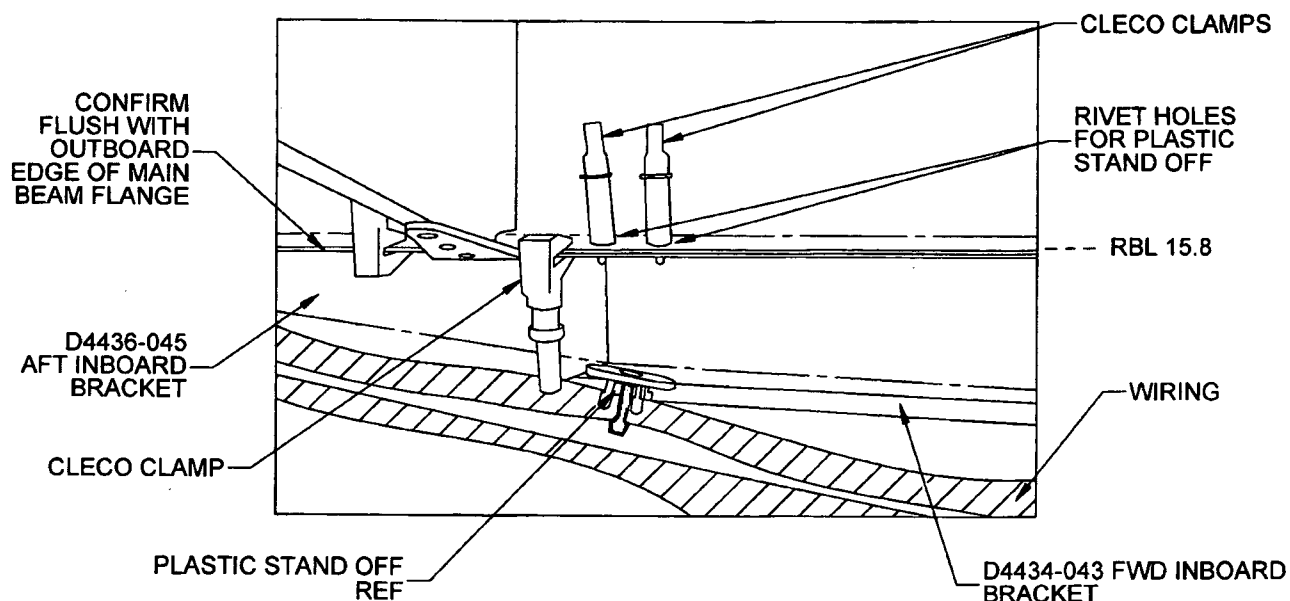


Figure 7. D4434-043 & D4436-045 Brackets Installation

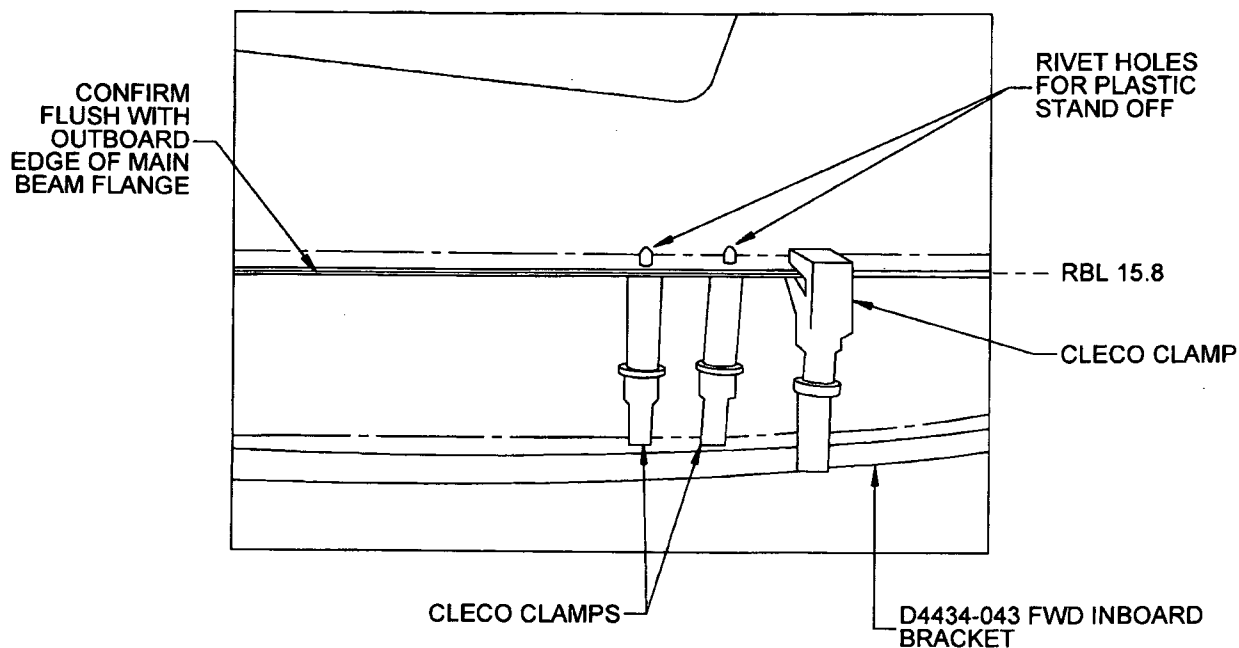


Figure 8. D4434-043 Fwd Inboard Bracket Installation



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MFG. APPR.	N/A	DSI 9590	SHEET 9 OF 15
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INSTALL
D4436-043
AFT OUTBOARD BRACKET
USING
AN3-3A BOLT (1)
NAS1149F0332P WASHER (2)
MS21042L3 NUT (1)
3 PL

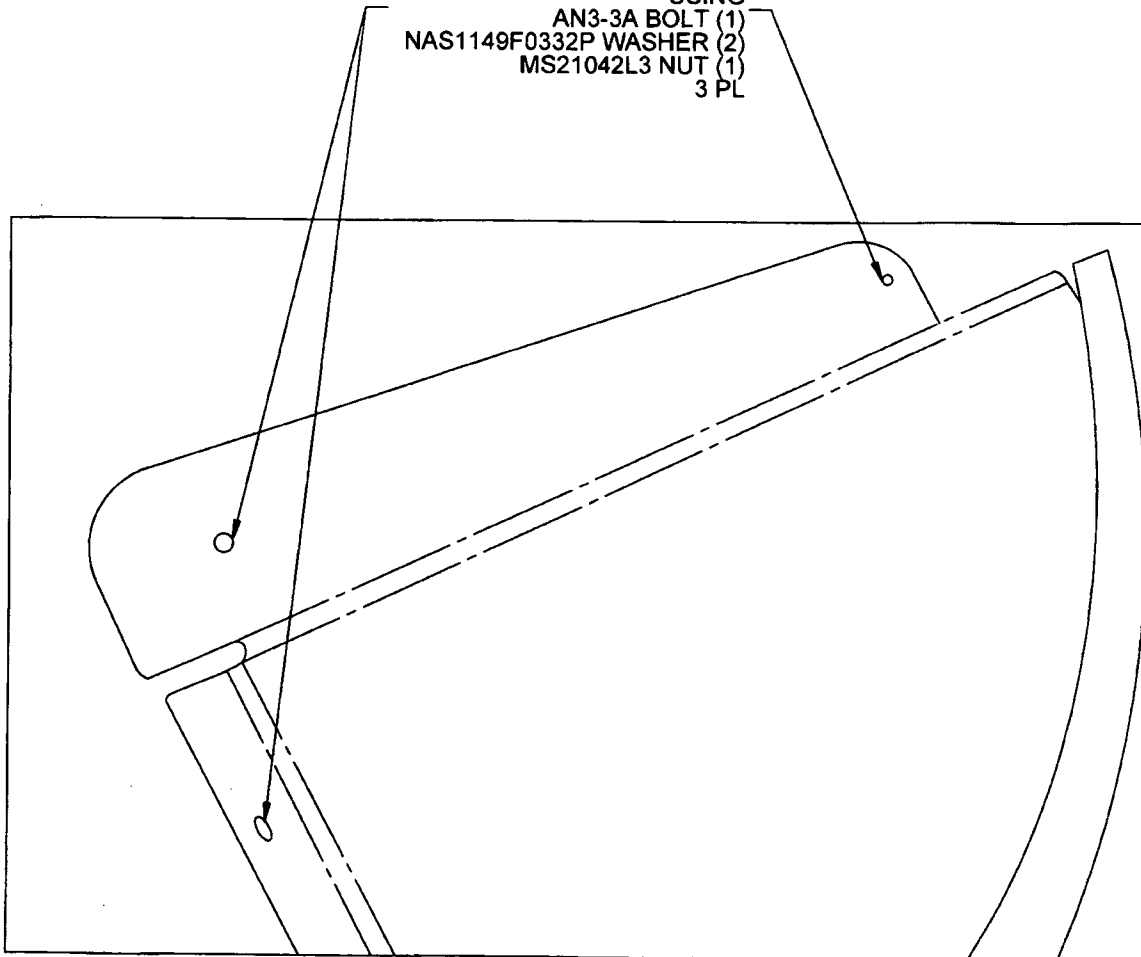






Figure 9. D4436-043 Aft Outboard Bracket Installation 

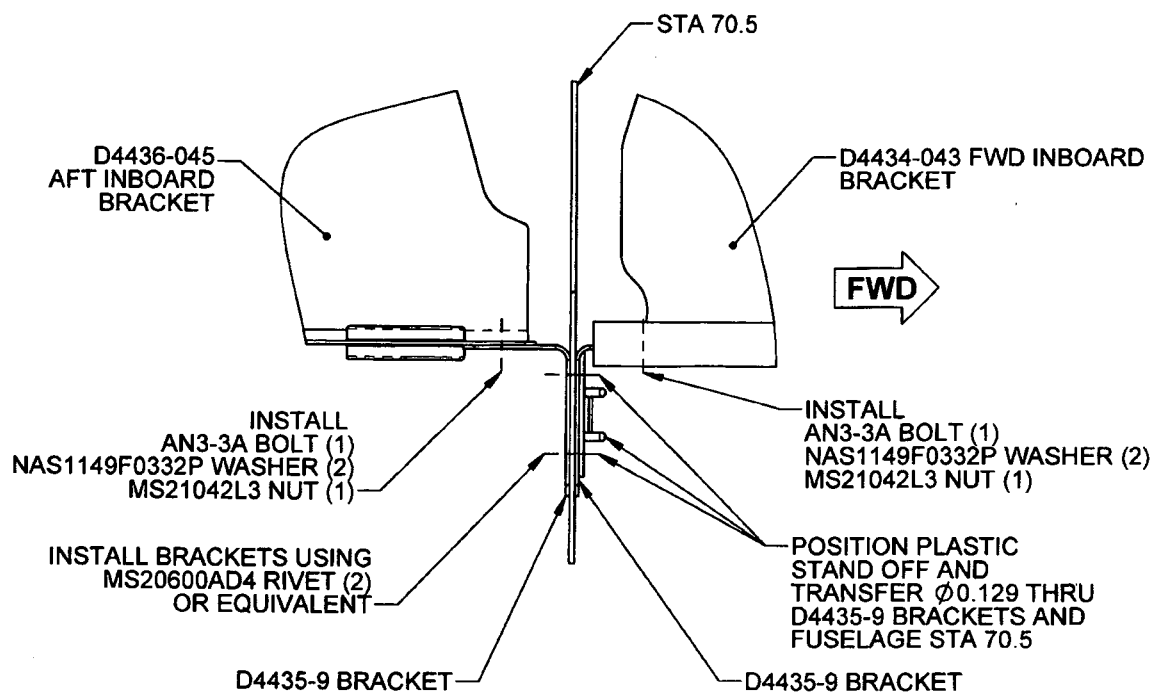
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LOOKING UP AT STA 70.5

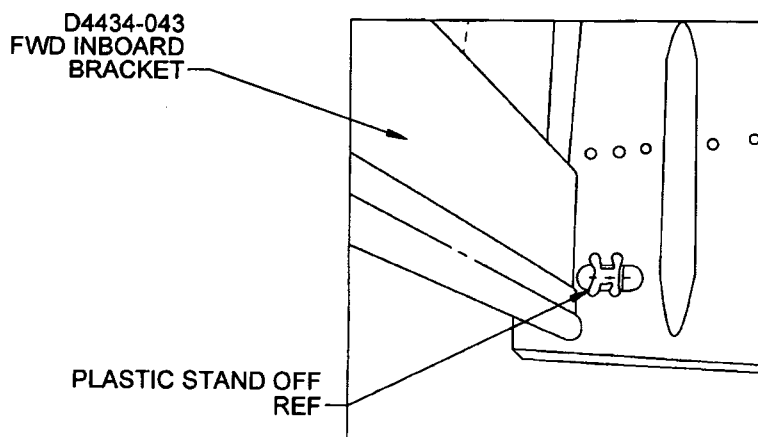


Figure 10. D4434-043 and D4435-9 Brackets Installation



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MFG. APPR.	N/A	DSI 9590	SHEET 11 OF 15
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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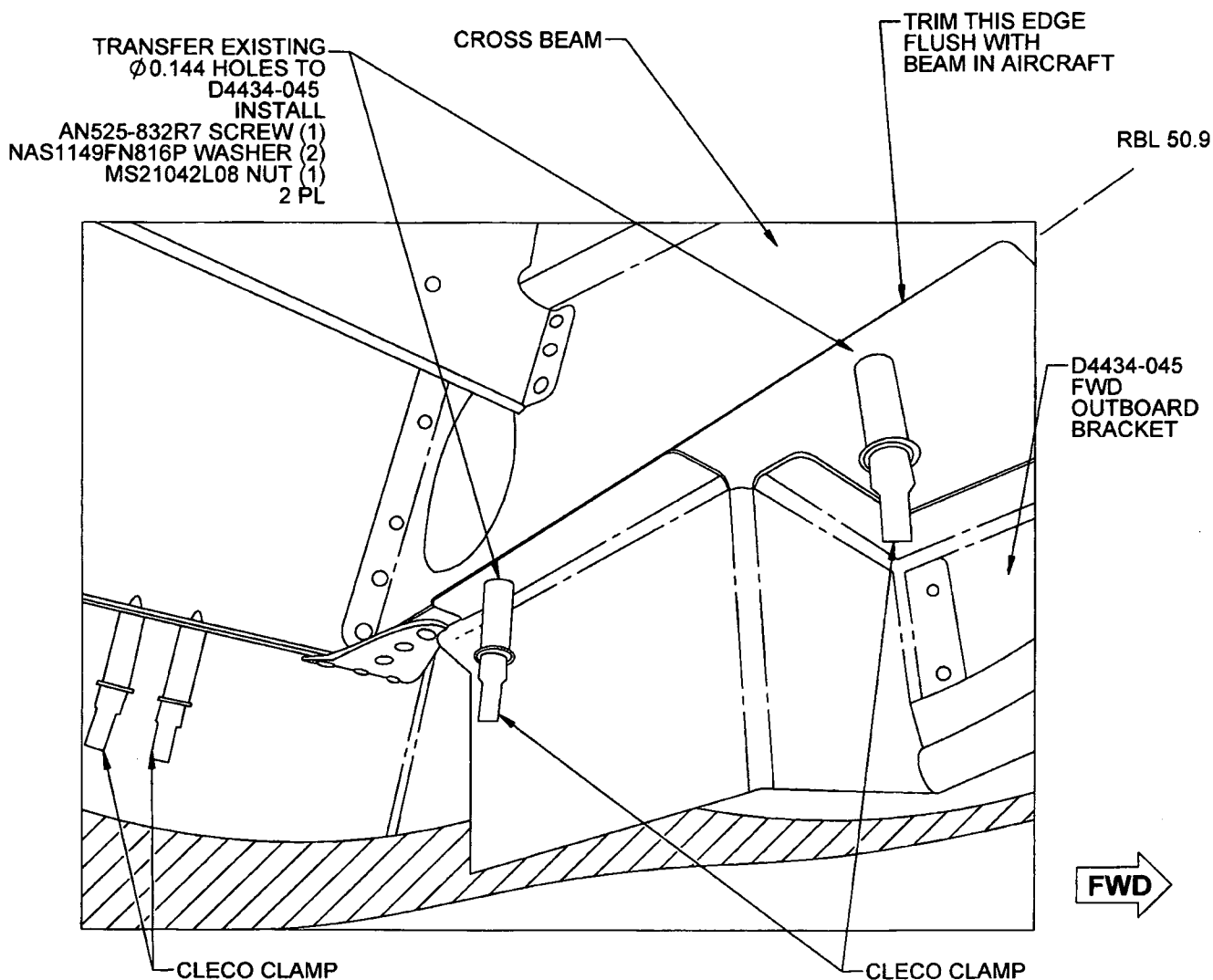


Figure 11. D4434-045 Bracket Installation D

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MFG. APPR.	N/A	DSI 9590	SHEET 12 OF 15
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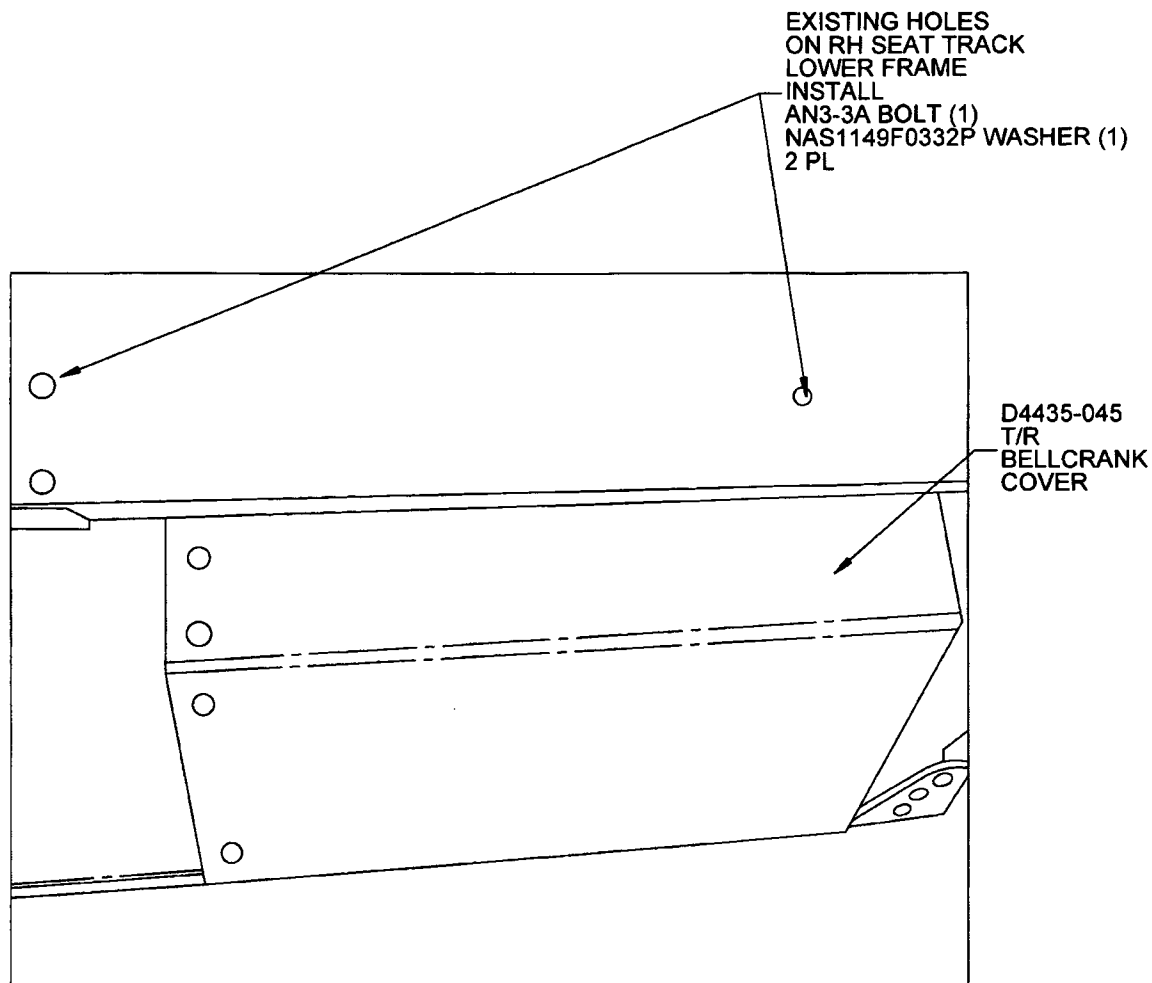


Figure 12. D4435-045 T/R Bellcrank Cover Installation D

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MFG. APPR.	N/A	DSI 9590	SHEET 13 OF 15
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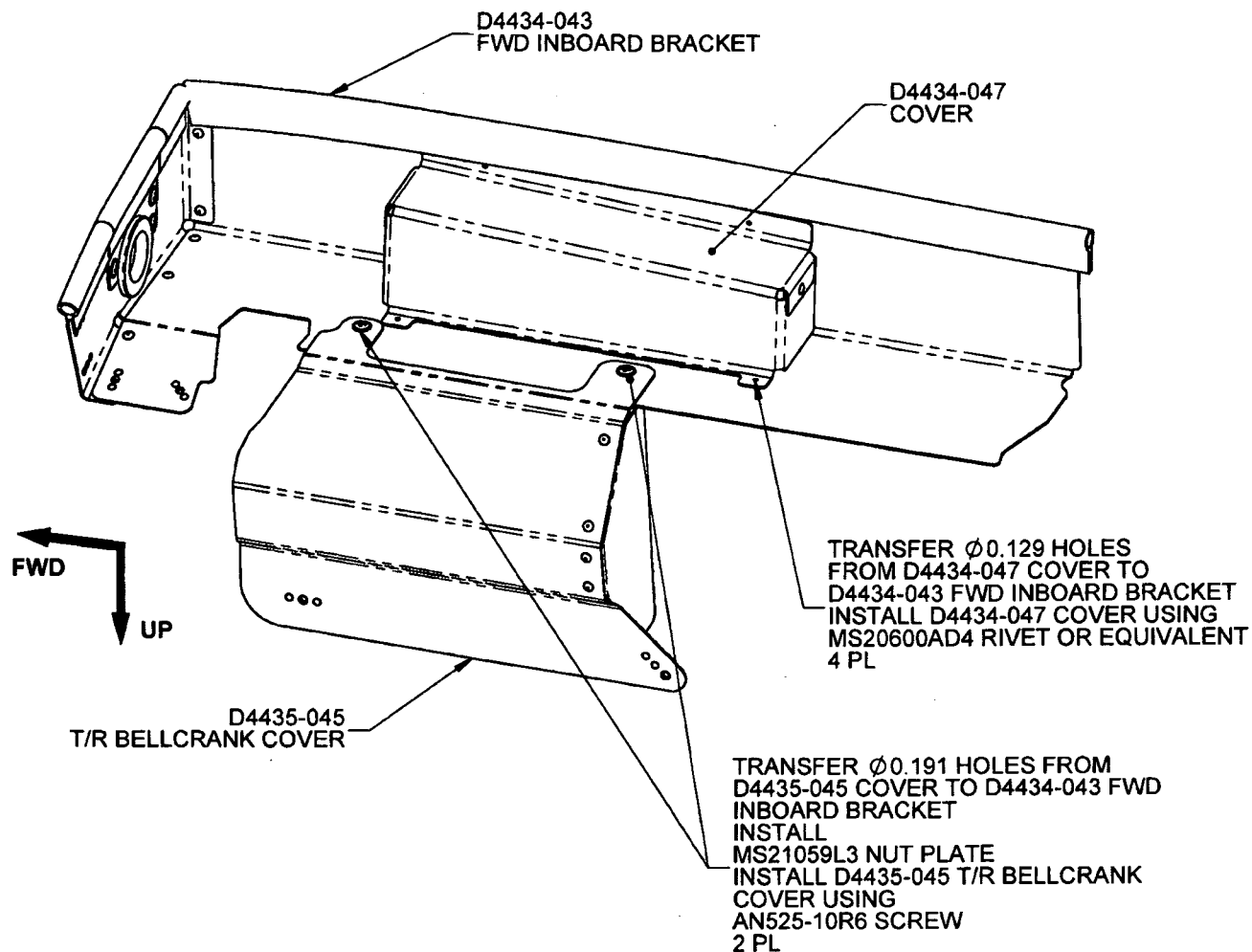


Figure 13. D4435-045 & D4434-047 Cover Installation

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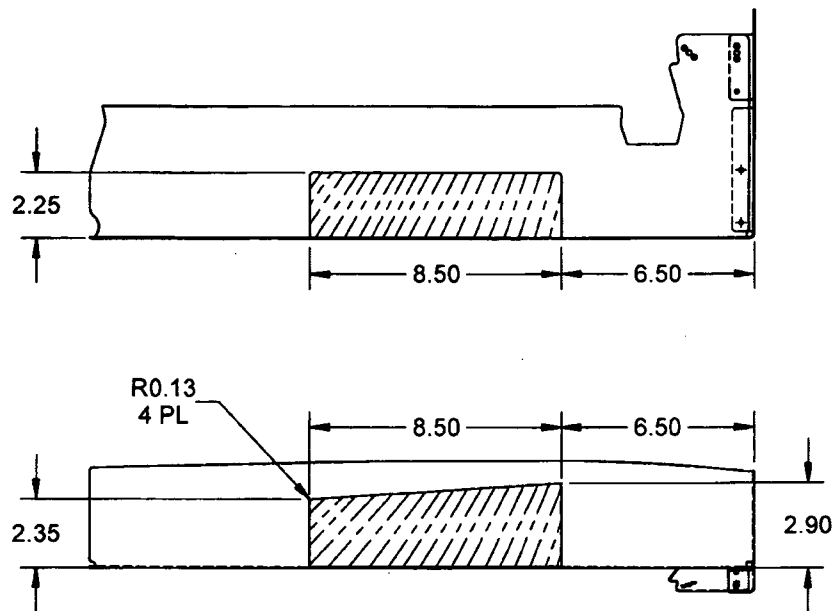
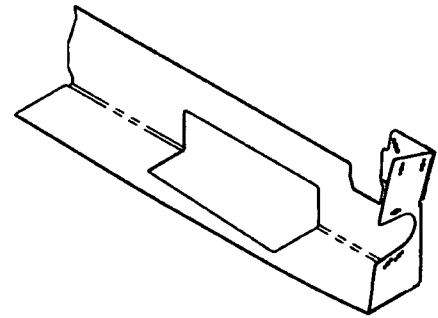


Figure 14. D4434-043 Fwd Inboard Bracket Cutout

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MFG. APPR.	N/A	DSI 9590	SHEET 15 OF 15
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2.0 Parts List

REFERENCE ONLY

B 113242
B 122465

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1	1		D4435-045	T/R BELL CRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELL CRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
17	15	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
1	1	1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

E

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kG	1.66 m	2.94 m-kG

4.0 Installation Procedure

Notes:



- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 D350-567-115 - OK to remove D3295-041
 D350-567-031 - OK to remove D3212-1
 D350-567-011 - OK to remove D2214
 D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

CANADA
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AIRCRAFT CERTIFICATION
BRANCH
DAO #01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

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MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 19
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